

ship Sept 15

Work Order ID 149063

149063

Page 1

Tuesday, July 19, 2016 2:41:27 PM

Item ID: D139-816-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 19 2016
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
DSI9686	A								
DSI9691	A								
IIN-D139-816	D								

DAS
6
9-89

AUG 17 2016

100 Document Control 0.00
DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file & type labels as per PPP D139-816-011 CHG005

DAS
21
9-89

SEP 14 2016

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

AUG 24 2016

28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

DQA: _____ Date: _____



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Picklist Print

Tuesday, July 19, 2016 2:41:30 PM

Page 1

Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 12/05/07 New Release DL
IPP Rev. B 12/11/08 Update dwg. DL
Dwg. Update 13/07/09 DL verf:DD
PER IIN REV.D DD VERF:JFS
DSI9686 JLM VERIFIED BY:DD
IPP Rev. C
IPP REV:D 13.12.23 AS
IPP REV E 14.04.01 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4634-041		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D4634-041									**	28 9-89		B149076	
Fwd, Center Ceiling Panel Assembly													
D4634-043		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D4634-043									**	28 9-89		B149072	
Middle, Center Ceiling Panel Assembly													
D4634-045		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D4634-045									**	28 9-89		B149126	
Aft, Center Ceiling Panel Assembly													
D4635-041		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D4635-041									**	28 9-89		B149136	
Fwd Ceiling Panel Assembly, LH													
D4635-042		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D4635-042									**	28 9-89		B149117	
Fwd Ceiling Panel Assembly, RH													
D4635-043		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D4635-043									**	28 9-89		B149121	
Aft Ceiling Panel Assembly, LH													
D4635-044		Manufactured	No			110	Each	0.0000	1	1			DAS 6 9-89
D4635-044									**	28 9-89		B149146	
Aft Ceiling Panel Assembly, RH													

DAS
27
9-89

DQA: _____ Date: _____



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Picklist Print

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Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

D4636-043

Manufactured No

110

Each

46.0000

16

16

D4636-043

Receptacle Bracket Assembly

**

4x 149059

DAS 6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST115

46

124109

2

126493

8

130828

36

D4636-11

Manufactured No

110

Each

29.0000

10

10

D4636-11

Bracket

**

149096x1

DAS 6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST115

29

126494

3

129248

26

D4636-5

Manufactured No

110

Each

29.0000

16

16

D4636-5

Bracket

**

149102

DAS 6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST115

29

129249

29

D4636-7

Manufactured No

110

Each

17.0000

4

4

D4636-7

Retainer Plate

**

4

DAS 6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST224

17

124519

4

129250

13

4

AUG 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

D4636-9 Manufactured No

110 Each 25.0000 1 1

D4636-9

Template

DAS 6 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST115

25

124315

25

D4648-1 Manufactured No

110 Each 9.0000 1 1

D4648-1

Template

DAS 6 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST224A

9

117658

6

119840

3

D4653-041 Manufactured No

110 Each 7.0000 6 6

D4653-041

Vent Manifold Assembly

B149134

DAS 6 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST224

3

141345

3

ST224A

4

129253

4

D4653-11 Manufactured No

110 Each 8.0000 6 6

D4653-11

Clamp

149154

DAS 6 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST224

2

125405

2

ST224A

6

127148

6

AUG 24 2016

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Material ☐		Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐		Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐		Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐		Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐		Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐		Manufacturing Process ☐	OTHER : _____					
Misidentified ☐		Past Due ☐						

Picklist Print

Tuesday, July 19, 2016 2:41:30 PM

Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

D4664-7 Manufactured No 110 Each 19.0000 3 3

D4664-7

Spacer

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST117

19

129262

19

D4712-043

Manufactured No

110 Each

24.0000

2

2

D4712-043

Bracket Assembly

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST224A

24

111161

1

125380

9

127232

14

D4716-1

Manufactured No

110 Each

9.0000

2

2

D4716-1

Duct Hose

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST221

9

125702

5

129265

4

D4716-3

Manufactured No

110 Each

16.0000

4

4

D4716-3

Duct Hose

DAS 28
6 9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

ST221A

16

125473

8

129266

8

AUG 2 4 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Tuesday, July 19, 2016 2:41:30 PM

Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

D4716-5 Manufactured No

110 Each 29.0000 6 6

D4716-5

Duct Hose

**

DAS 6 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST221b

17

125704

17

ST222a

12

129267

12

D4728-057 Manufactured No

110 Each 21.0000 1 1

D4728-057

Ps7J1 Jumper

**

DAS 6 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

MF002

6

117935

6

MF009

15

124738

15

D4728-063 Manufactured No

110 Each 21.0000 1 1

D4728-063

Cabin Temp Sensor Jumper Assembly

**

DAS 6 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

MF002

21

117938

6

124750

15

D4730-020-035 Manufactured No

110 Each 16.0000 24 24

D4730-020-035

Velcro Strip 2.0W/ X 3.5L

**

DAS 6 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST638

16

125419

14

130051

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Tuesday, July 19, 2016 2:41:30 PM

Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

D5032-1 Manufactured No

110 Each 15.0000 16 16

D5032-1

Doubler

**

149097

DAS DAS
6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST143

15

126462

15

D5032-3 Manufactured No

110 Each 21.0000 16 16

D5032-3

Doubler

**

149073

DAS DAS
6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST143

21

126463

21

2351-20-21-C3C Purchased No

110 Each 90.0000 16 16

2351-20-21-C3C

STUD

**

DAS
DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST579

90

M128068

18

m130595

72

50-009-2 Purchased No

100 Each 97.0000 16 16

50-009-2

Grommet

**

DAS
DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST562

97

m128047

47

m131501

50

16
9

AUG 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					

Picklist Print

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Tuesday, July 19, 2016 2:41:30 PM

Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

AN970-3

Purchased

No

110

Each

205.0000

10

10

AN970-3

Washers

**

68-6
9
DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

198

m129630

198

ST321

7

m128057

7

10

DAS
27
9-89

BT1.5I-M

Purchased

No

110

Each

954.0000

24

24

BT1 5I-M

Tie Wrap

**

68-6
9
DAS
28
9-89

Location

Loc Qty

Loc Code

over008

954

m128238

954

24

DAS
27
9-89

BT3LH-L

Purchased

No

110

Each

271.0000

12

12

***BT3I H-I ***

Tie Wrap

**

68-6
9
DAS
28
9-89

Location

Loc Qty

Loc Code

over008

200

m128238

200

st552

71

m128238

71

12

DAS
27
9-89

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Tuesday, July 19, 2016 2:41:30 PM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, July 19, 2016 2:41:30 PM

Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,377.000

35

35

MS21042L3

Nut

DAS 6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

CCK007

600

m135056

600

FP001

14

m133790

14

GA

579

m134360

112

m135135

467

OVER007

700

m135135

700

ST303

484

m134039

12

m134943

472

35

MS24694-S51

Purchased

No

110

Each

123.0000

36

36

MS24694-S51

Screw

DAS 6 28
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST284

123

m133990

123

36

AUG 24 1989

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Tuesday, July 19, 2016 2:41:30 PM

Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-15

Purchased

No

110

Each

261.0000

21

21

MS27039-1-15******

Screw

DAS
27
9-89LocationLoc QtyLoc Code

GA

21

m127916

21

over006

100

m134852

100

ST280

140

m132640

140

21

NAS1149D0316J

Purchased

No

110

Each

1,592.000

5

5

NAS1149D0316.J******

Washer

DAS
27
9-89LocationLoc QtyLoc Code

ST264

1592

M134502

1592

5

NAS1149D0332J

Purchased

No

110

Each

1,720.000

34

34

NAS1149D0332.J******

Washer

DAS
27
9-89LocationLoc QtyLoc Code

CA

6

m129682

6

FP001

558

m134848

558

GA

979

m135046

979

ST264

177

m134502

6

m134738

171

34

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, July 19, 2016 2:41:30 PM

Work Order ID: 149063

149063

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0663J

Purchased

No

110

Each

701.0000

6

6

NAS1149D0663.J

Washer

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST263

469

M135135

469

ST269

5

M126334

5

CB200

Purchased

No

110

Each

9.0000

3

3

CB200

Acrylic Adhesive, 3.5G

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

PKG

9

m133800

1

m134943

8

CS125-1032-8AACR

Purchased

No

110

Each

52.0000

2

2

CS125-1032-8AACR

Stud

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST547

52

M130277

52

D5078-1

Manufactured

No

110

Each

6.0000

1

1

D5078-1

Bracket

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST148

6

125455

6

DAS 28
6 9-89
9-89

AUG 2 1 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide an alternate method of installing the D139-816-011 Interior Ceiling Panel Kit for customers with newer 300 series aircraft models with split center ceiling panels.

2.0 PROCEDURE

This procedure modifies step 3.1.7 of IIN-D139-816 Rev. D.

- 2.1 Position the D4634-041/-043/-045 center panels onto the p/n E4417F01 cabin isolation mounts using $\varnothing 0.25"$ (6 mm) holes in the panels. Identify those mounts that do not align with holes in the panels. Ensure that a gap between the D4634-041/-043/-045 panels of approximately 0.050" (1.3 mm) is maintained.
- 2.2 Remove extra and non-aligning cabin isolation mounts from the ceiling. Temporarily install the removed mounts into non-align holes in the panels and paint mark the back of the E4417F01 mounts. Position the D4634-041/-043/-045 center panels onto p/n E4417F01 cabin isolation mounts. Ensure the new mount locations get marked in the cabin roof. Remove panels keeping the mounts on the panels.
- 2.3 Remove ceiling insulation from aircraft ceiling at the new marked mount locations.
- 2.4 Apply a small amount of CB 200 Click Bond adhesive to the E4417F01 cabin isolation mounts that are being relocated.
- 2.5 Reposition the ceiling panels on the ceiling pressing the E4417F01 cabin isolation mounts firmly on the ceiling and holding in position until the adhesive cures enough to remove the screws from the mount.
- 2.6 Install the necessary rivets to re-fasten the E4417F01 cabin isolation mounts to the ceiling.
- 2.7 Continue the ceiling panel installation as indicated in the IIN-D139-816.

3.0 GENERAL NOTE

- 3.1 Due to the thermoforming process variations in material thickness may occur. It is acceptable to install longer or shorter Dzus fasteners as required to accommodate this material variation.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

For D139-816-011 & CHG 005 and later, the following parts have been added to the kits.

QTY. -011	PART NUMBER	DESCRIPTION
X	D139-816-011	INTERIOR CEILING PANEL KIT
3	CB 200	3.5g ACRYLIC ADHESIVE

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NO. 149063 NCS
1607-19

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ALTERNATE INSTALLATION	NTS
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DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to install the D5078-1 Bracket to support the Overhead Connector for D139-811-011 Interior Ceiling Panel Kit.

2.0 PROCEDURE

This procedure is added after step 3.1.39 of IIN-D139-816 Rev. D.

- 2.1 Position the D5078-1 Bracket on the LH side of the cabin overhead by temporarily removing 2x MS27039-1 screws as shown in Figure 1. Transfer 2x $\varnothing 0.204$ " (#6 drill) holes from airframe to the D5078-1 Bracket. Deburr and touch-up holes with MIL-P-85582 or MIL-P-23377 primer.
- 2.2 Install D5078-1 Bracket using existing 2x MS27039-1 screws and washers as shown in Figure 1.
- 2.3 Install overhead cannon plug in the D5078-1 Bracket using existing NAS1801/1802 screws and existing AS85049/95-20A-A Perimeter Mounting Flange as shown in Figure 2.
- 2.4 Reconnect wire harness to overhead cannon plug as shown in Figure 2.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

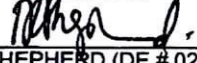
5.0 PARTS LIST

The D5078-1 bracket has been added to D139-816-011 Kits at CHG 005 and later. Customers who wish to obtain the D5078-1 Bracket for a kit that has already been installed can procure the DSI 9691-011 kit from Dart as outlined below.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9691-011	BRACKET KIT
1	D5078-1	BRACKET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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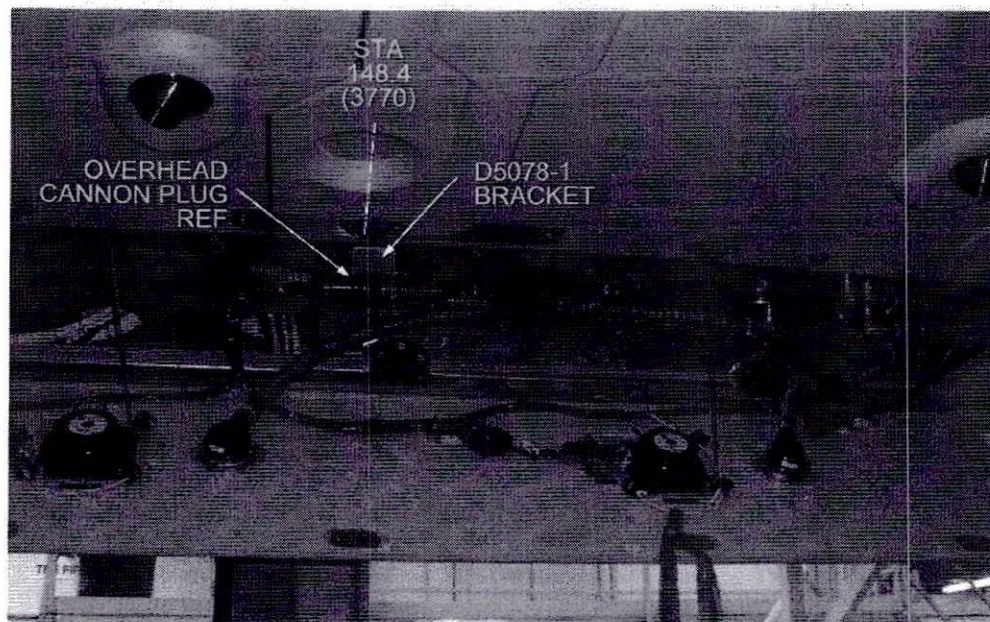


Figure 1. - LH Side Overhead Panel

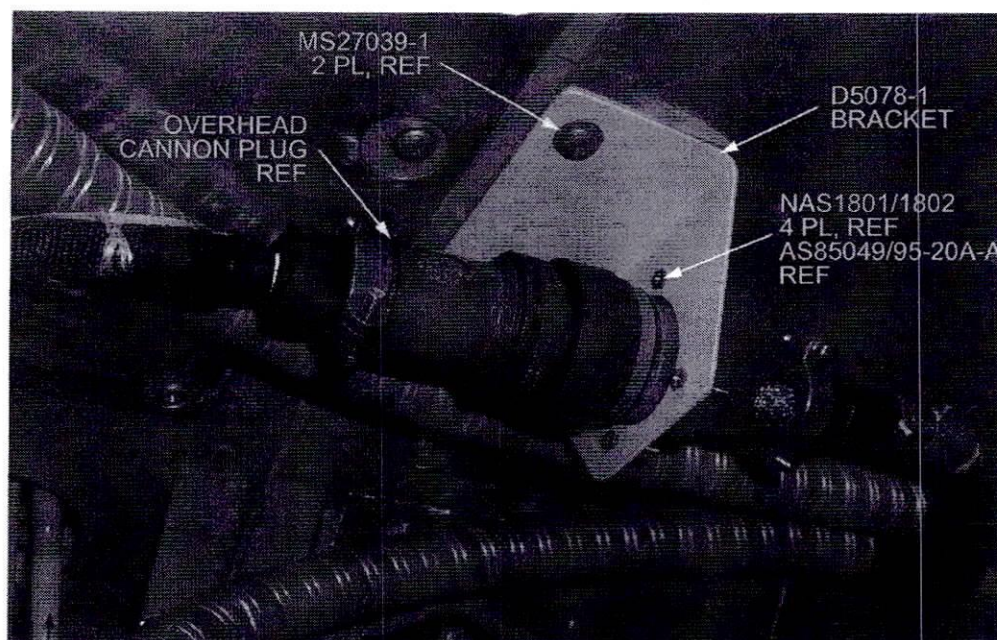


Figure 2. - D5078-1 Bracket Installation

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET INSTALLATION	NTS
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5.0 PARTS LIST

REFERENCE ONLY

Qty -011	Part Number	Description
X	D139-816-011	INTERIOR CEILING PANEL KIT
1	D4634-041	FWD, CENTER CEILING PANEL ASSEMBLY
1	D4634-141	* FWD, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-043	MIDDLE, CENTER CEILING PANEL ASSEMBLY
1	D4634-143	* MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-045	AFT, CENTER CEILING PANEL ASSEMBLY
1	D4634-145	* AFT, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-041	LH, FWD CEILING PANEL ASSEMBLY
1	D4635-141	* LH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-042	RH, FWD CEILING PANEL ASSEMBLY
1	D4635-142	* RH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-043	LH, AFT CEILING PANEL ASSEMBLY
1	D4635-143	* LH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-044	RH, AFT CEILING PANEL ASSEMBLY
1	D4635-144	* RH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
16	D4636-043	RECEPTACLE BRACKET ASSEMBLY
10	D4636-11	BRACKET
16	D4636-5	BRACKET
4	D4636-7	RETAINER PLATE
1	D4636-9	TEMPLATE
1	D4648-1	TEMPLATE
6	D4653-041	VENT MANIFOLD ASSEMBLY
6	D4653-11	CLAMP
3	D4664-7	SPACER
2	D4712-043	BRACKET ASSEMBLY
2	D4716-1	DUCT HOSE
4	D4716-3	DUCT HOSE
6	D4716-5	DUCT HOSE
1	D4728-057	HARNESS ASSEMBLY
1	D4728-063	HARNESS ASSEMBLY
24	D4730-020-035	VELCRO STRIP
16	D5032-1	DOUBLER
16	D5032-3	DOUBLER
16	2351-20-21-C3C	DZUS SCREW
16	50-009-2	GROMMET
10	AN970-3	WASHER
24	BT1.5I-M	TIE WRAP
12	BT3LH-L	TIE WRAP
1	CB 200	3.5g ACRYLIC ADHESIVE
2	CS125-1032-8-AA-CR	STUD (or CS125-1032-8-AA-CRM)
35	MS21042L3	NUT
36	MS24694-S51	SCREW
21	MS27039-1-15	SCREW
5	NAS1149D0316J	WASHER (or AN960JD10L)
34	NAS1149D0332J	WASHER (or AN960JD10)
6	NAS1149D0663J	WASHER (or AN960JD616)

NOTES: (*) DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE
D4634-141/-143/-145 ARE REPLACEMENT PANELS
D4635-141/-142/-143/-144 ARE REPLACEMENT PANELS

Work Order ID 149063

149063

Tuesday, July 19, 2016 2:41:27 PM

Item ID: D139-816-011

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: Lightweight Interior Ceiling Panels

Start Date: 7/7/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals:

Process Plan:

21

Date: JUL 19 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

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IIN-D139-816

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Document Control

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DOCUMENT CONTROL

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Photocopy blue file & type labels as per PPP D139-816-011 CHG005

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see attachment

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

Change Record

PAGE 1 OF 1

Part Number: D139-816-011

Description: INTERIOR CEILING PANEL

[illegible]